

Date: Wednesday, 3/21/2007 3:40:51 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP LEG		
Job Number	31407B			Part Number	D2278		
Estimate Number	10353			Drawing Number	D2278 REV E		
P.O. Number	N/A			Project Number	N/A		
This Issue	3/21/2007	S.O. No.	N/A	Drawing Revision	E		
Prsh Rev.	NC	Type	SMALL /MED FAB	Material	N/A		
First Issue	N/A			Due Date	4/10/2007		
Previous Run	30813B			Qty:	40	Um:	Each
Written By							
Checked & Approved By							
Comment	Est Rev:A	New Issue	05-11-07	JLM			
	Est Rev:B	Now 6061-T6	06-06-23	JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s) Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick (M6061T6S.080) 15.459 Identify as D2278 Batch: M104326 X 15 ml 07 06 08	M103961 x 25 25.765
2.0	WATER JET	FLOW WATER JET	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP LEG

Job Number: 31407B

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Po 7/8/27 30

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SYLVR

C 7/8/27 30

8.0 QC21 FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

1 Due 18/6/27

Job Completion



U 57-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		TOOK 2x Pieces FOR TEST of Deburring Machine. w/o. 00207	JUL 09 2018		2.		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

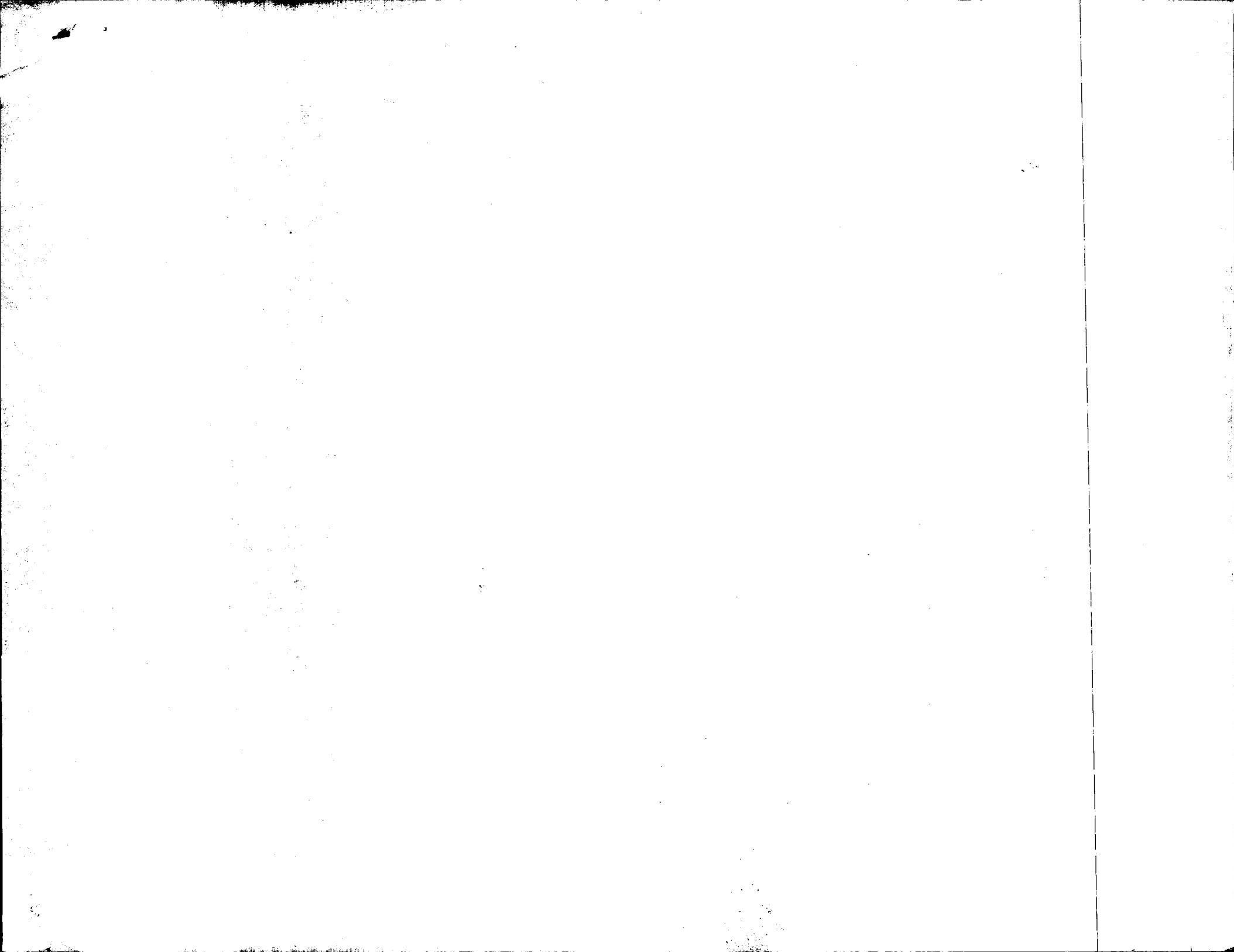
DART AEROSPACE LTD	Work Order:	31407B
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07.06.08	Date:	07.06.11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

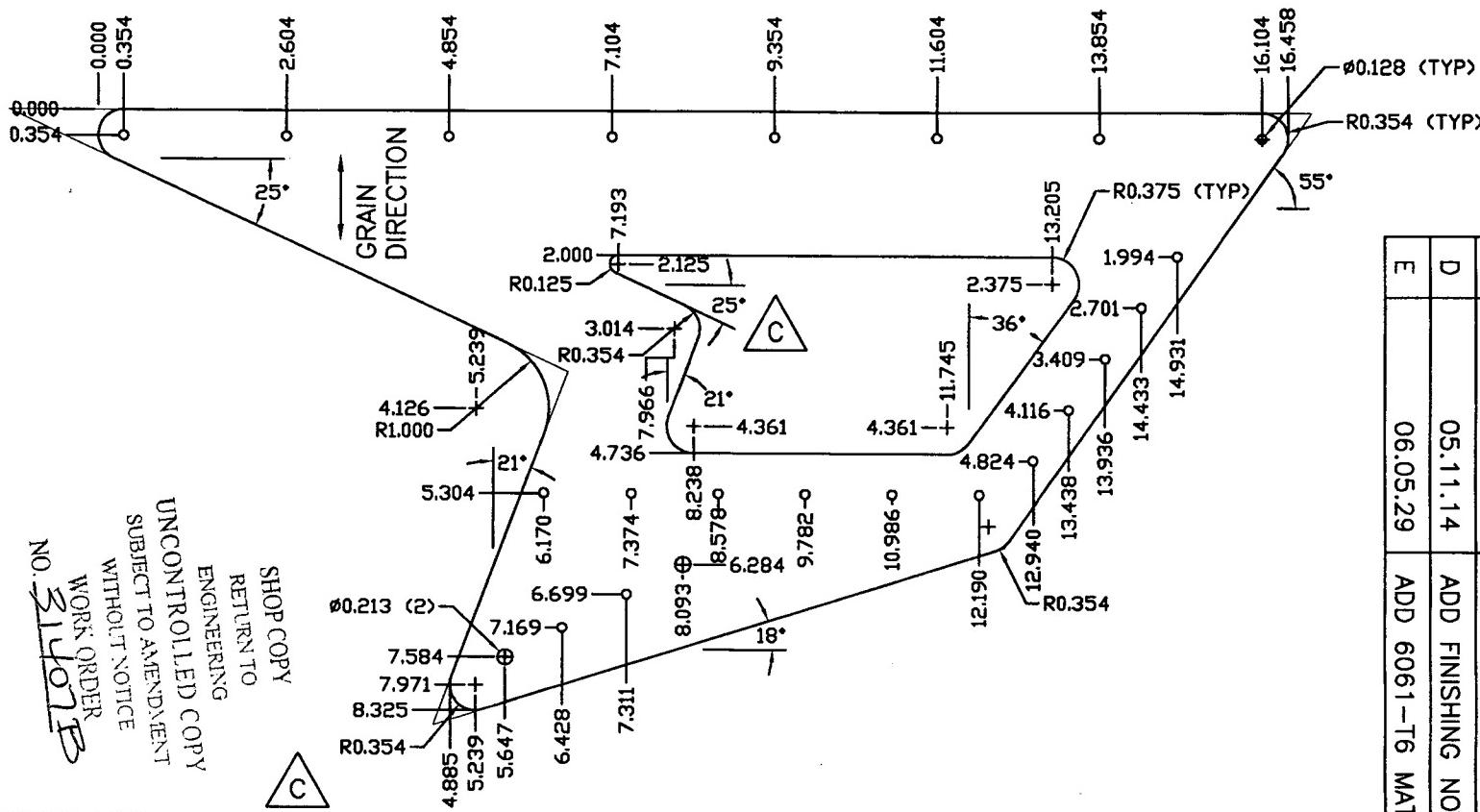


RELEASED

06.06.20

DART

DRAWN BY		DART AEROSPACE LTD		REV. E
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA	
P/H	M	D2278		SHEET 1 OF 1
DATE		TITLE		
06.05.29		LEG		
C	95.02.16	CHANGED RADIUS TO 0.354		
D	05.11.14	ADD FINISHING NOTE		
E	06.05.29	ADD 6061-T6 MATERIAL		
			1:2.5	SCALE



D2278 LEG

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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